REPORT DOCUMENTATION PAGE
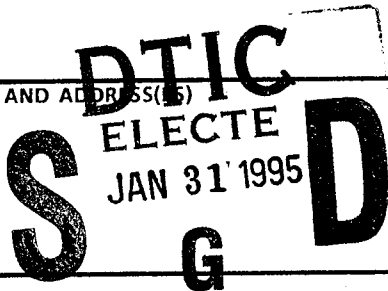
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1. AGENCY USE ONLY (Leave blank)	2. REPORT DATE 06/00/78	3. REPORT TYPE AND DATES COVERED

4. TITLE AND SUBTITLE
DETAILED SAMPLING AND QUALITY CONTROL PROCEDURES FOR THE CALGON WATER TREATMENT FACILITY AT ROCKY MOUNTAIN ARSENAL

5. FUNDING NUMBERS

6. AUTHOR(S)
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7. PERFORMING ORGANIZATION NAME(S) AND ADDRESS(ES)

ROCKY MOUNTAIN ARSENAL (CO.)
  COMMERCE CITY, CO

8. PERFORMING ORGANIZATION REPORT NUMBER

81356R61

9. SPONSORING / MONITORING AGENCY NAME(S) AND ADDRESS(ES)

10. SPONSORING / MONITORING AGENCY REPORT NUMBER

DTIC
ELECTE
S JAN 31 1995
G D

11. SUPPLEMENTARY NOTES

12a. DISTRIBUTION / AVAILABILITY STATEMENT

APPROVED FOR PUBLIC RELEASE; DISTRIBUTION IS UNLIMITED

12b. DISTRIBUTION CODE

13. ABSTRACT *(Maximum 200 words)*

THIS PAPER IS INTENDED TO COVER THE SAMPLING AND QUALITY CONTROL PROCEDURES FOR THE CALGON CARBON ADSORPTION SYSTEM WHICH TREATS THE GROUND WATER AT THE NORTH BOUNDARY OF RMA.

DTIC QUALITY INSPECTED 3

14. SUBJECT TERMS

GROUNDWATER, CHEMICALS

15. NUMBER OF PAGES

16. PRICE CODE

17. SECURITY CLASSIFICATION OF REPORT	18. SECURITY CLASSIFICATION OF THIS PAGE	19. SECURITY CLASSIFICATION OF ABSTRACT	20. LIMITATION OF ABSTRACT
UNCLASSIFIED			

DETAILED SAMPLING AND QUALITY CONTROL PROCEDURES

FOR THE CALGON WATER TREATMENT FACILITY

AT

ROCKY MOUNTAIN ARSENAL

81356R61
original

IN SUPPORT OF PROGRAM

UNDER ITARMS 1.05.12

By

Process Development and Evaluation Division of

The Contamination Control Directorate

ROCKY MOUNTAIN ARSENAL
Commerce City, Colorado 80022

June 1978

19950127 092

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INTRODUCTION:

This paper is intended to cover the sampling and quality control procedures for the Calgon Carbon Adsorption System which treats the ground water at the north boundary of Rocky Mountain Arsenal. The samples frequency and their location are given below.

LOCATION	SAMPLE FREQUENCY (OR READING)	PHASE
Influent to filter	Up to 15/day with random grab samples	Start-up
Filter effluent	Up to 15/day with random grab samples	
Adsorber effluent	Up to 15/day with random grab samples	
Differential pressure across filters	1/hr. during 8 hr. work day	
Totalizer flow	1/hr. during 8 hr. work day	
Instant flow	Up to 15/day with random readings taken at time of grab samples	
Influent to filter	2/day and 1 random grab sample	Psuedo Steady State (Stabilization Period)

Reasons for control charts:

(1) Early warning* of DIMP breakthru.
(2) Records of plant operation.
(3) Verification of experiments leading to plant.
(4) Early warning* out of control conditions.
(5) Plant problems pinpointed thus trouble-shooting simplified.
(6) Day-to-day operation can be monitored and changes made studied.

The levels of certain materials in the ground water in the vicinity of the Calgon Plant have been closely ranged and can be used for an initial baseline. This baseline will be altered by the new information so as to maintain a realistic and current baseline. For the materials (contaminates) which have no prior

* The control chart is an excellent indicator of when the contaminate levels have exceeded standards set by the Project Managers Office.

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history a baseline can be started using the first 8-10 analyses samples and updated as new analyses are reported. Both inputs of data, prior history and no prior history contaminates, will be loaded into the SIAO computer to generate control charts on the applicable chemicals and water qualities. Thus, not only will a bookkeeping of these materials be made but a monitoring of plant operations can also be made.

LOCATION	SAMPLE OR READING FREQUENCY	PHASE
Filter Effluent	2/day and 1 random grab sample/week	Stabilization Phase
Differential Pressure	1/day during 8 hr. work day	
Totalizer Flow	1/day during 8 hr. work day	
Instant Flow	2/day	
Influent to Filter	1/day and 1 random grab sample/week	
Filter Effluent	1/day and 1 random grab sample/week	Steady State Phase
Adsorber Effluent	1/day and 1 random grab sample/week	
Differential Pressure Across Filters	1 week	
Totalizer Flow	1 week	
Instant Flow	1/day and 1 random reading/week	

Chemicals similar to those being tested for will have an effect on the control charts. Thus, some of the new unknown chemicals can be detected from control chart variations. Periodic testing of samples for all constituents plus control chart monitoring should enable unknown and/or new chemical compounds to be reliably found when the chemical compounds first make their appearance.

ADDITIONAL INFORMATION:

1. Compounds tested for with prior level history and the approximate ranges of contaminate levels.

1.1. Those compounds having known prior levels will have the previous levels incorporated into the statistical baseline with the new data updating the control chart parameters. This method of updating leads to accurate and stable control chart levels.

2. Compound tested for with no prior level history (baseline).

2.1. The first ten inputs of data will be used to set the initial control chart point. The data from the samples which follow ~~which are to~~ will be used to update the control chart parameters. Again, accuracy and stability of the control chart levels will be continually improved.

CALGON PLANT OPERATIONS (QC PROGRAM)

Some notes: Use of control charts

$\bar{X}$ - Mean

$\pm 3\sigma$ - ~~Gives~~ means only .3% of all values fall outside by random change-- 99.7% that fall outside ~~otherwise~~ are significant deviations and indicate process exceeding limit.

How $\bar{x}$ values shown -- baseline from history and computation of similar operations in same industrial environment.

SAMPLE GRAPH - See attached.

What should be plotted: DIMP   DCPD (monitor only)
                          pH   Conductivity
                          TOC   Fls
                          Suspend Sol   Differ. press. filter

Data flow: Samples to MALD -- analysis for compounds listed.

Results to SIAO -- plot of control charts

Results to PDE -- record and control of equipment

Partial results to Calgon --- contract requirements

Special Note: Some compounds / qualities have no statistical baseline, therefore, running baseline statistics will be generated using the formulation below:

(1) Subgroup averages method:

$$\bar{x} \pm 3\sigma_{\bar{x}} = x + \frac{3\sigma'}{\sqrt{n}}$$

$\bar{x}$ = sub group average

$\sqrt{\bar{x}}$ = std. dev. of population of average of sub group

$\sqrt{s}$ = std. dev. of population of individ. values

n = number of values in each sub group

(2) Series subgroup method (better):

$\bar{x}$ = average of subgroup

R = Range = maxi - min value of subgroup

$\bar{\bar{x}}$ = Average of all subgroups taken

$\bar{R}$ = Average range of all subgroups

Statistics Calculated:

Averages	$\bar{\bar{x}} + A_2\bar{R}$	$\bar{\bar{x}} - A_2\bar{R}$
Ranges	$D_4 \bar{R}$	$D_3 \bar{R}$
	Upper limit	Lower limit

A_2, D_4, D_3 From charts of Control Limit Factors

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SAMPLE FREQUENCY AND SIZE: Rationale

It was determined after a technical and statistical analysis that the sample frequency could be reduced to one sample per day of 2 liter size. The size of the sample was set by MALD and Calgon Technical Department -- each group needed a liter sample to perform the indicated analyses. The sample frequency was set from two constraints: (1) the concentration levels from one hour to the next hour will not significantly vary since the influent water is well mixed*, and (2) the dewatering wells concentration levels change very little from one week to the next week. The first constraint indicates the concentration levels of contaminants will not build-up nor dilute over a period of time at any point except where the adsorption process is taking place or at the filter. The second constraint indicates the feed (influent) water contaminate levels to the Calgon Plant can be expected to remain fairly constant over long periods (months) of time. With these two constraints, well-mixed and pseudo-steady contaminates' levels, it was decided to take samples at the following frequencies:

Start-up Phase[+] = 15 samples and/or readings per day

(Stabilization) Pseudo-steady State = (1 month-6 months) 2 samples and/or readings per day

Steady State = (6 months - indefinitely) 1 sample and/or reading per day

NOTE: Adjustments in the number of samples and/or readings per day may have to be made if influent water to the Calgon Plant varies greater than previous history has indicated.

* - Due to turbulent flow and changes in pipe diameter & direction.

+ - A certain amount of grab samples will be pulled during the plant start-up.

X̄ AND R DATA SHEET AND CONTROL CHART

DIVISION		DATE	OPERATION		CHARACTERISTIC
C C		NOW	TEST		CLOUDY
SPEC. REQUIREMENT AND TOLERANCE			UNIT OF MEASURE		INSPECTOR
+/-			IN		QA MAN

$UCL_{\bar{x}} = \bar{\bar{X}} + A_2\bar{R} = 2791.1$

$LCL_{\bar{x}} = \bar{\bar{X}} - A_2\bar{R} = 2048.4$

$UCL_R = D_4\bar{R} = 645.3$

$LCL_R = D_3\bar{R} = 0.0$

$\bar{\bar{X}} = \dfrac{\Sigma \bar{X}}{N} = 2419.7$

$\bar{R} = \dfrac{\Sigma R}{N} = 197.5$

SAMPLE NUMBER	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18
X1	1540	1200	950	668	757	628	676	1148	1202	2229	1581	1056	2561	2917	2941	3198	2888	3985
X2	1498	1118	888	703	693	681	688	1158	2857	895	1685	2413	3199	2593	3434	3865	2719	3878
X3																		
X4			6															
X5																		
ΣX	3000	2378	1838	1043	1450	1309	1356	2307	3208	3114	3176	4968	5470	5696	6375	6203	5513	6076
AVG	1500.0	1166.3	915.0	621.5	715.0	654.5	679.0	1163.5	1094.5	1557.0	1586.8	2834.6	2735.8	2765.8	3167.6	3191.5	2760.5	3397.5
HIGH	1540	1200	950	668	757	681	688	1158	2857	2229	1591	2413	3199	2917	3454	3198	2888	3878
LOW	1498	1118	888	703	683	628	676	1148	1202	895	1685	1056	2561	2593	2941	3865	2713	3985
RANGE	02	158	78	77	44	63	2	0	055	1244	6	767	748	928	493	133	67	05

X̄ CHART — UCL / AVG / LCL

R CHART — UCL / AVG / LCL